

**Work Order ID 72681**

Friday, August 05, 2011 12:39:11 PM

Page 1

Item ID: D4271-011

Accept

Revision ID:

Item Name: Fwd Beam Assembly

Start Date: 8/5/2011 Start Qty: 1.00

Required Date: 8/5/2011 Req'd Qty: 1.00

Reference: rework to Rev D

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4271

D

100

0.00



Small Fab

Small Fab

**Memo**

PULL FROM STOCK:  
1 X D4271-011 B68722  
REMOVE BOTH PLATES  
D4274-1 AND DISCARD/SCRAP  
RETURN TO STOCK:  
D4281-1 B66705  
D4149-5 B66897  
1- Pick and Assemble as per dwg  
D4271 REV D  
D4271-025 B 72642

0.00

110

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

**Memo**

0.00

EP 8/11/11

④

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4271-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:    Date: 11.08.15

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>72681</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/08/15	100	When took apart 1 rivet broke off can't removed it D4281-1 SPACU.	<u>  </u> 03/24	Scrap + destroy	<u>  </u> 11/08/15	<u>  </u> 11/08/15	<u>  </u> 03/24	<u>  </u> 11/08/15

**NOTE:** Date & initial all entries

**Work Order ID 72681**

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Page 2

Item ID: D4271-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Beam Assembly

Start Date: 8/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00



Customer:

Reference: rework to Rev D

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

RESTOCK USING NEW B/N

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

# Picklist Print

Friday, August 05, 2011 12:39:08 PM

Page 1

Work Order ID: 72681

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 8/5/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC  
11.01.26 RevB dwg EC verified by:DD  
per PD1 EC verified by:JLM

IPP RevA  
IPP RevC 11.07.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4149-5		Manufactured	No				Each	7.0000					
---------	--	--------------	----	--	--	--	------	--------	--	--	--	--	--



Eyebolt Stud

Location

ST133

Loc Qty

7

Loc Code

7

D4271-011



Fwd Beam Assembly

Manufactured	No		Each	0.0000
--------------	----	--	------	--------

B68722

~~B 72681~~ (K)

D4271-025



End Fitting Assembly Fwd Beam

Manufactured	No		Each	0.0000
--------------	----	--	------	--------

B 72642 (K)

D4281-1



Spacer

Manufactured	No		Each	20.0000
--------------	----	--	------	---------

Location

ST139

Loc Qty

20

Loc Code

20

71930

8/5/08/12  
B66897 (K)

8/5/08/12

8/5/08/12

8/5/08/12

B66

**Work Order ID 68722**

Wednesday, April 20, 2011 10:21:49 AM

Page 1

Item ID: D4271-011

Accept

Revision ID:

Item Name: Fwd Beam Assembly

Start Date: 4/20/2011 Start Qty: 2.00

Required Date: 4/25/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: ☒

Date: 4/20/2011

Tooling:

Date:

QC: ☐

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4271

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Pick and Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Identify as per dwg &amp; Stock Location: 196

0.00



Packaging

Memo

0.00

Packaging

EP 11/04/20 (2)

(72)

11/4/20 20 28

**Work Order ID 68722**

Wednesday, April 20, 2011 10:21:49 AM

Page 2



Item ID: D4271-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Beam Assembly

Start Date: 4/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							11/4/25 MF 11-04-25

# Picklist Print

Wednesday, April 20, 2011 10:21:56 AM

Page 1

Work Order ID: 68722

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 4/20/2011





Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev:A 10.11.18 new issue DD ver:EC  
11.01.26 RevB dwg EC verified by:DD

IPP RevA

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4149-5  Eyebolt Stud		Manufactured	No			100	Each	2.0000	1	2		4/11/20	Return to Stock
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST133			2						
				66897			2						
D4274-1  Plate, Fwd Support		Manufactured	No			100	Each	6.0000	2	4		4/11/20	Scrapped on 72681
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST139B			6						
				68163			6						
D4275-1  Fwd Beam		Manufactured	No			100	Each	3.0000	1	2		4/11/20	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				st200			3						
				65884			3						
D4281-1  Spacer		Manufactured	No			100	Each	4.0000	1	2		4/11/20	Return to Stock (Scrap 1)
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST139			4						
				66705			4						

# Picklist Print

Wednesday, April 20, 2011 10:21:56 AM

Page 2

Work Order ID: 68722

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C12A

Purchased

No

100

Each

51.0000

6

12



Bolts

Location

Loc Qty

Loc Code

ST351

51

116924

6

117313

45

AN4C13A

Purchased

No

100

Each

35.0000

2

4



BOLT

Location

Loc Qty

Loc Code

ST353

35

117366

35

MS20615-4M18

Purchased

No

100

Each

346.0000

8

16



Rivet

Location

Loc Qty

Loc Code

ST323

346

117411

346

MS21043-3

Purchased

No

100

Each

948.0000

6

12



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP-B

-5

112314

-5

ST301

873

112314

873

Wednesday, April 20, 2011 10:21:56 AM

Shop Packet Print

Page 2



# Picklist Print

Wednesday, April 20, 2011 10:21:56 AM

Page 3

Work Order ID: 68722

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

100

Each

1,180.000

2

4



Nut



*ES 11/04/20*

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

600

117423

600

ST301

540

114523

3

116188

237

116549

300

*4.*

NAS1149C0332R

Purchased

No

100

Each

5,261.000

12

24



Washer



*ES 11/04/20*

Location

Loc Qty

Loc Code

ST297

5261

116304

55

117291

4606

117460

600

*24*

NAS1149C0432R

Purchased

No

100

Each

6,492.000

4

8



Washer



*ES 11/04/20*

Location

Loc Qty

Loc Code

ST297

6492

116900

1492

117291

5000

*0*

Wednesday, April 20, 2011 10:21:57 AM

Shop Packet Print

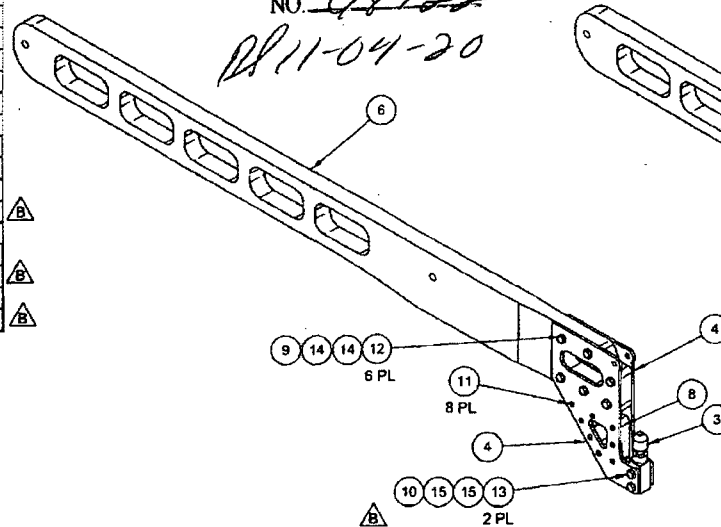
Page 3

SHOP COPY  
RETURN TO  
ENGINEERING

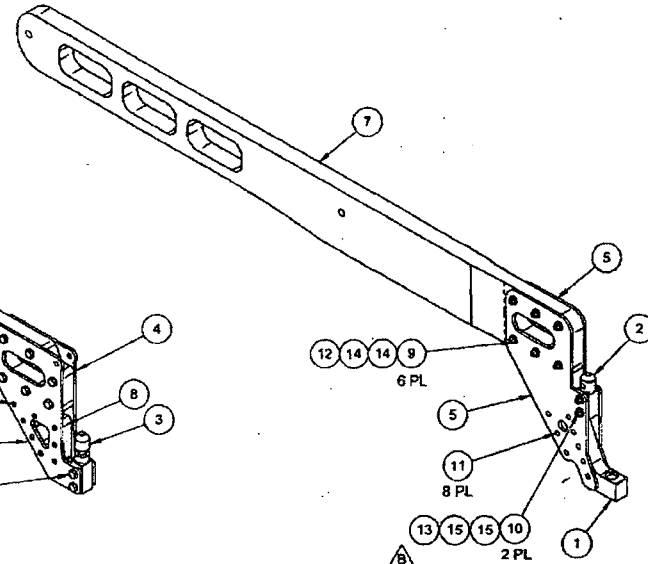
UNCONTROLLED COPY

SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *48722*  
*DR11-04-20*

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	6	6	AN3C12A	BOLT
10	2	2	AN4C13A	BOLT
11	8	8	MS20615-4M18	RIVET
12	6	6	MS21043-3	NUT
13	2	2	MS21043-4	NUT
14	12	12	NAS1149C0332R	WASHER
15	4	4	NAS1149C0432R	WASHER



**D4271-011 FWD BEAM ASSEMBLY**



**D4271-013 AFT BEAM ASSEMBLY**

**RELEASED**  
2010-12-06

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.12.01		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. **D4271**  
TITLE **SUPPORT BEAM ASSEMBLIES**  
SCALE **NTS**  
REV. B  
SHEET 1 OF 2  
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